

Work Order ID 105740

105740

Page 1

August-16-13 11:37:33 AM

Item ID: D350-600-242

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacepod Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/13/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 13-08-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3188	F
DSI9639	A
IIN D350-600	Rev C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-600-242/CHG001

DAS
38
9-89

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes in D3188-2 using drill jig DT8971
2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-2 as per Dwg D3188.

14-11-14

14-11-17

PTO

NCR: Yes ☒ No ☐

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: 14/12/08Date: 14/12/08

QA Closed:

Date:

Work Order: <u>105740</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D350-600-242</u>		Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input checked="" type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. <u>14-4362</u>					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input checked="" type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Other <u>HAND WARE CHANGE</u>	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled
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Work Order ID 105740

August-16-13 11:37:33 AM

105740

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Item ID:	D350-600-242	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:				Stop		*NS2*
Item Name:	Spacepod Fwd Opening RH AS 350/AS 355					
Start Date:	8/16/13	Start Qty:	1.00	*1*	Cust Item ID:	
Required Date:	9/13/13	Req'd Qty:	1.00	*1*	Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- inspect part completeness to step on W/O Memo	0.00 0.00							
130 *130* Small Fab Small Fab	Small Fab Memo 1-Cut D2986 Neoprene Foam per template D2986T1 2- Adhere D2986 foam to bottom side of D3187-2 spacepod floor using contact adhesive A/R Batch: _____	0.00 0.00							
140 *140* Small Fab Small Fab	Small Fab Memo ****This step separates hardware, previous steps is for body & floor****	0.00 0.00							

8/16/14

U/A as per floor
03187-2
14/11/14

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data	<input type="checkbox"/>										
Equip/Tooling	<input type="checkbox"/>										
Operator	<input type="checkbox"/>										
Material	<input type="checkbox"/>										
Setup	<input type="checkbox"/>										
Other	<input type="checkbox"/>										
Process	<input type="checkbox"/>										
Supplier	<input type="checkbox"/>										
Training	<input type="checkbox"/>										
Unapproved	<input type="checkbox"/>										

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Work Order ID 105740

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August-16-13 11:37:33 AM

Item ID: D350-600-242 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacepod Fwd Opening RH AS 350/AS 355
 Start Date: 8/16/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/13/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600 ***Hardware on previous steps is for door ass'y**** 1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight. Install insert. A/R Hysol batch: <u>m129562</u> expire date: <u>02/14/2014</u> A/R Milled fibres batch: <u>m129562</u> 2- Prime (grey) as necessary per OSI005 Primer batch: <u>130636</u> CA 14/11/14 Hardner batch: <u>130858</u> 3-Attach Neoprene Foam to floor using Contact Cement A/R Contact Cement Batch: <u>S N/A as per floor</u> QC5- Inspect part completeness to step on W/O QC Quality Control								
170		0.00							
170	QC	0.00							
Quality Control	Memo								

S N/A as per floor
 D3187-2 Smp
 14/11/14
 14/11/14

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 105740

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Item ID: D350-600-242 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacepod Fwd Opening RH AS 350/AS 355
 Start Date: 8/16/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/13/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* HandFinish Hand Finishing	Wing Walk as per dwg QS1005 4.4 Batch <u>W30289</u> Memo Wing Walk Spacepod top surface of Pod as per Dwg D3188	0.00 0.00				<u>14/11/14</u>	<u>Sh</u>		
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00					<u>8 Oct 11/14</u>		
200 *200* Packaging Packaging	Pick Kit Memo	0.00 0.00				<u>14/11/14</u>	<u>Sh</u>	<u>DAS</u> <u>05</u> <u>1-89</u>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 105740

August-16-13 11:37:33 AM

105740

Page 5

Item ID: D350-600-242

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacepod Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/13/13

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC4- 100% Inspect kits for completeness

0.00

210

QC

Memo

0.00

Quality Control

14-11-17

220

Packaging

0.00

220

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-600-242

Location: 030

PPP Rev:

DAS
06
9-89

NOV 17 2014

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.00

Quality Control

14/11/18

14-11-18

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

November-04-14 11:46:14 AM

Page 1

Work Order ID: 105740

105740

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A07.03.07 new issue EC
 IPP rev B 07.04.16 reformat, D3188 rev.E EC
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove
 D3188-2m add D3188-6 DD 10.04.07 verified
 by:JLM IPP REV:F
 13.02.06 AS PER DSI9639 REV.A DD VERF:JLM IPP REV:G 14.07.30
 as per DSI9701 rev.a DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2985 *D2985* Label	DAS 38 9-89	Manufactured	No				Each	16.0000		1		4/11/17	DAS 38 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST014			16						
				104987			9						
				106718			7						
D2985-3 *D2985-3* Decal, RH Install	DAS 38 9-89	Manufactured	No				Each	6.0000		1		4/11/17	DAS 38 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST014			6						
				96952			6						
D5127-1 *D5127-1* Shim, Large		Manufactured	No				Each	11.0000		2		4/11/14	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST137			11						
				123193			3						
				125150			8						

Picklist Print

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Page 2

Work Order ID: 105740

105740

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

D5127-3

Manufactured No

Each

11.0000

2

D5127-3

Shim, Small

DAS
27
8-29
14/14/14

Location

Loc Qty

Loc Code

ST136

3

123195

3

ST137

8

125370

8

D3188-6

Manufactured No

110

Each

2.0000

1

1

D3188-6

Spacepod Body

DAS
27
8-29
14/14/14

Location

Loc Qty

Loc Code

CA

2

105750

1

105753

1

D3015-3

Manufactured No

130

Each

96.0000

1

D3015-3

Locknut

DAS
27
8-29
14/14/14

Location

Loc Qty

Loc Code

FG

18

95758

8

96151

10

ST015

78

111465

2

117832

76

B111465

1

Picklist Print

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Page 3

Work Order ID: 105740

105740

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

AN526C832R24

Purchased

No

140

Each

100.0000

4

4

AN526C832R24

screw

**

27
0-00
14/11/14

Location

Loc Qty

Loc Code

ST327

100

118870

34

124255

66

140

Each

28.0000

1

1

AN960JD516

NAS1149D0563J

Purchased

No

AN960JD516

Washer

**

DAS
27
0-00
14/11/14

Location

Loc Qty

Loc Code

Return2014

28

122452

18

125807

10

140

Each

0.0000

20

20

AN960JD8

NAS1149DN832

Purchased

No

AN960JD8

Washer

D2179

Manufactured

No

140

Each

33.0000

2

2

D2179

Hinge Bracket Plate

**

DAS
27
0-00
14/11/14

DAS
27
0-00

Location

Loc Qty

Loc Code

ST004

33

106233

24

35432

9

Picklist Print

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Page 4

Work Order ID: 105740

105740

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

D2237

Manufactured No

140 Each

87.0000

2 2

D2237

Striker Plate

DAS
27
9-09
14/11/14

Location

Loc Qty

Loc Code

ST005

87

108708

1

112911

1

116707

15

121380

20

121746

50

D2986

Manufactured No

140 sf

0.0000

5.915789

D2986

Black Neoprene 2" X 3"

D3538-1

Manufactured No

140 Each

17.0000

2 2

D3538-1

Hinge Bracket

DAS
27
9-09
14/11/14

DAS
27
9-09
14/11/14

Location

Loc Qty

Loc Code

FG

12

105999

4

115602

1

84630

1

98281

6

ST048

5

115602

1

118849

3

98281

1

Picklist Print

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Page 5

Work Order ID: 105740

105740

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

D3554-7

Manufactured No

140 Each

35.0000

1 1

D3554-7

Ball Stud

**

DAS
27
9-09

Location

Loc Qty

Loc Code

FG

5

87039

5

ST049

30

87039

8

87571

22

D3567-2

Manufactured No

140 Each

5.0000

1 1

D3567-2

Decal

**

DAS
27
9-09

Location

Loc Qty

Loc Code

ST049

5

50375

5

MS20426AD4-5

Purchased No

140 Each

448.0000

4 4

MS20426AD4-5

RIVET

**

DAS
27
9-09

Location

Loc Qty

Loc Code

ST312

448

6874

70

m125807

378

ALS4-1032-130

AELS4-1032-130 Purchased No

150 Each

3,247.000

28 28

ALS4-1032-130

Rivnut

**

DAS
27
9-09

Location

Loc Qty

Loc Code

ST267

3247

M126109

57

M128211

48

M128649

3142

Picklist Print

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Work Order ID: 105740

105740

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00 **DAS**

AN526C832R10

Purchased

No

150

Each

147.0000

10

10

AN526C832R10

Screw

14/11/14 **DAS**
27
9-89

Location

Loc Qty

Loc Code

ST327

147

123831

47

m127363

100

10

AN526C832R14

Purchased

No

150

Each

297.0000

2

2

AN526C832R14

Screw

14/11/14 **DAS**
27
9-89

Location

Loc Qty

Loc Code

ST327

297

124215

297

2

AN960JD10

NAS1149D0363J

Purchased

No

150

Each

11.0000

2

2

AN960JD10

WASHER

14/11/14 **DAS**
27
9-89

Location

Loc Qty

Loc Code

ST335

11

116393

11

B128429

2

D2228

Manufactured

No

150

Each

62.0000

4

4

D2228

Backing Plate

14/11/14 **DAS**
27
9-89

Location

Loc Qty

Loc Code

ST004

62

105984

31

73380

4

95704

27

7

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Picklist Print

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Page 7

Work Order ID: 105740

105740

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

D2464	Manufactured	No	150	f	953.5316	10.8	11.36842
-------	--------------	----	-----	---	----------	------	----------

D2464

Seal(\$per foot)

SM
4/11/14

Location

Loc Qty

Loc Code

ST409

953.531579

110770

96.28

121946

841.631579

83543

15.62

121946

11.368

D2585

Manufactured No

150 Each

57.0000

2

2

D2585

Latch Clamp

DAS
27
00
4/11/14

Location

Loc Qty

Loc Code

ST008

57

108520

1

112571

1

114114

1

121867

24

123519

30

1

Picklist Print

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Work Order ID: 105740

105740

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

D2586

Manufactured No

150 Each

75.0000

2 2

D2586

Door Latch

DAS
27
14/11/14

Location

Loc Qty

Loc Code

FG

13

100607

2

114985

1

119746

4

83893

5

95760

1

ST479

30

124208

30

ST483

32

108573

24

113641

5

114985

2

121779

1

D2621

Manufactured No

150 Each

34.0000

2 2

D2621

Latch Plate

DAS
27
14/11/14

Location

Loc Qty

Loc Code

FG

2

88616

2

ST008A

32

108138

3

115195

1

119046

7

123542

21

Picklist Print

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Work Order ID: 105740

105740

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

D2857-1

Manufactured No

150 Each

57.0000

1 1

D2857-1

Hinge Bracket

DAS

27

8-09

Location

Loc Qty

Loc Code

FG

5

82261

4

91914

1

ST012

52

110247

1

113744

3

120387

24

121829

24

D2857-2

Manufactured No

150 Each

43.0000

1 1

D2857-2

Hinge Bracket

DAS

27

8-09

Location

Loc Qty

Loc Code

FG

3

78904

3

ST012

40

100769

1

108401

1

114154

24

121410

14

D3557-1

Manufactured No

150 Each

5.0000

1 1

D3557-1

Bracket

DAS

27

8-09

Location

Loc Qty

Loc Code

ST049

5

73384

5

Picklist Print

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Work Order ID: 105740

105740

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00 **DAS**

MS21042L08

Purchased

No

150

Each

2,582.000

18

18

MS21042L 08

Nut

14/11/14
27
8-89

Location

Loc Qty

Loc Code

ST304

2582

123900

1

125445

268

m127304

99

m127410

50

m128401

1393

m128429

69

m129541

102

m130325

600

DAS
27
8-89

MS21042L3

Purchased

No

150

Each

1,106.000

2

2

MS21042L 3

Nut

14/11/14

Location

Loc Qty

Loc Code

ST305

1106

123900

815

M127410

11

M127831

41

M128401

42

M128754

197

DAS
27
8-89

MS27039-08-11

Purchased

No

150

Each

442.0000

2

2

MS27039-08-11

SCREW

14/11/14

Location

Loc Qty

Loc Code

ST282

442

m130358

442

~~123900~~

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Work Order ID: 105740

105740

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 4.00

MS27039-1-15

Purchased

No

150

Each

263.0000

2

2

MS27039-1-15

Screw

**

14/11/14
DAS
65
9-89

Location

Loc Qty

Loc Code

ST285

263

124326

12

m127916

251

2

8-8
27
DAS
65
9-89

NAS1515H3

Purchased

No

150

Each

353.0000

2

2

NAS1515H3

Washer

**

14/11/14

Location

Loc Qty

Loc Code

FG

10

123301

10

ST266

343

m128635

107

m129521

236

2

SHP

D350-600-449

Manufactured

No

200

Each

1.0000

1

1

D350-600-449

Switch Relocation

DAS
38
9-89

**

14/11/14

DAS
65
9-89

Location

Loc Qty

Loc Code

FG125

1

106058

1

200

Each

1.0000

1

1

K10021

Manufactured

No

K10021

Spacepod Hardware (-241)

DAS
33
9-89

**

14/11/14

DAS
65
9-89

Location

Loc Qty

Loc Code

FG125

1

106226

1

110

Each

0.0000

1

1

D3186-4

Manufactured

No

D3186-4

Spacepod Door, RH

105742

**

14-11-04

November-04-14 11:46:17 AM

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Picklist Print

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Work Order ID: 105740

105740

Parent Item: D350-600-242

D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

D3187-2

Manufactured No

110

Each

2.0000

**

D3187-2

Floor Panel

3A
9-6

Location

Loc Qty

Loc Code

ST241A

2

B12S311

105760

2

A3235-020-935

Purchased

No

110

Each

336.0000

8

8

**

A3235-020-935

Washer, Countersunk

Location

Loc Qty

Loc Code

ST266

336

106150

136

M128403

200

8

DAS
27
8-09

14/11/14

DART SERVICE INSTRUCTION

TO AMEND IIN-D350-600 REV. E OR EARLIER
AND ICA-D350-600 REV. 5 OR EARLIER
REF TCCA STC: SH93-88
REF FAA STC: SR00098NY/SR00099NY
REF EASA STC: EASA.IM.R.S.01292

1.0 PURPOSE:

IT HAS COME TO DART'S ATTENTION THAT THE INFORMATION SHOWN ON D2985 DECAL CAN BE MISINTERPRETED WHEN ONLY A LH OR RH SPACEPOD IS INSTALLED ON AN AIRCRAFT. THEREFORE, THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO ADD THE D2985-1/-3 DECALS AS OUTLINED BELOW.

2.0 INSTRUCTIONS:

IT IS ACCEPTABLE TO REPLACE D2985 WITH D2985-1/-3 AS FOLLOWS:

D2985-1: FOR LH INSTALLATIONS ONLY (REF. D35X-600-141/-143/-241/-243)

D2985-3: FOR RH INSTALLATIONS ONLY (REF. D35X-600-142/-242)

3.0 PARTS LIST

QTY -141	QTY -142	QTY -143	QTY -241	QTY -242	QTY -243	PART NUMBER	DESCRIPTION
X						D350-600-141	SPACEPOD... LH, AS350
	X					D350-600-142	SPACEPOD... LH, AS350/AS355
		X				D355-600-143	SPACEPOD... LH, AS355
			X			D350-600-241	SPACEPOD... LH, AS350
				X		D350-600-242	SPACEPOD... LH, AS350/355
					X	D355-600-243	SPACEPOD... LH, AS355

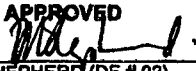
1	1	1	1	1	1	D2895	DECAL
1		1	1		1	D2895-1	LH DECAL (ADD)
	1			1		D2895-3	RH DECAL (ADD)




4.0 WEIGHT AND BALANCE

NO CHANGE.

5.0 MAINTENANCE:

MAINTAIN D2985-1/-3 PER ITEM 5.2.7 OF ICA-D350-600.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED 
BY: D. SHEPHERD (DE # 02)
DATE: 12.12.07
CERT. NO.: SH93-88
ISSUE NO.: 6

A	NEW ISSUE	SFM	12.12.04
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SFM	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9639	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DECAL CHANGE	NTS
DATE	12.12.04	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

105740

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

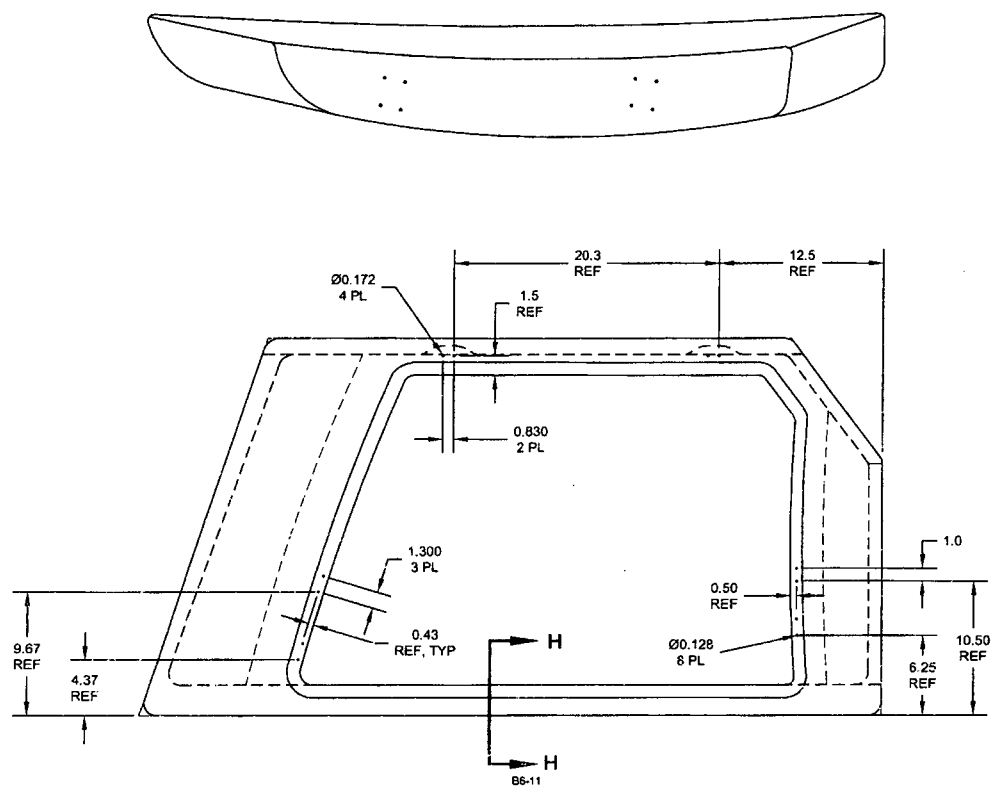
9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

105740 MLJ
130816

RELEASED
2009-10-20
MD

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

105740



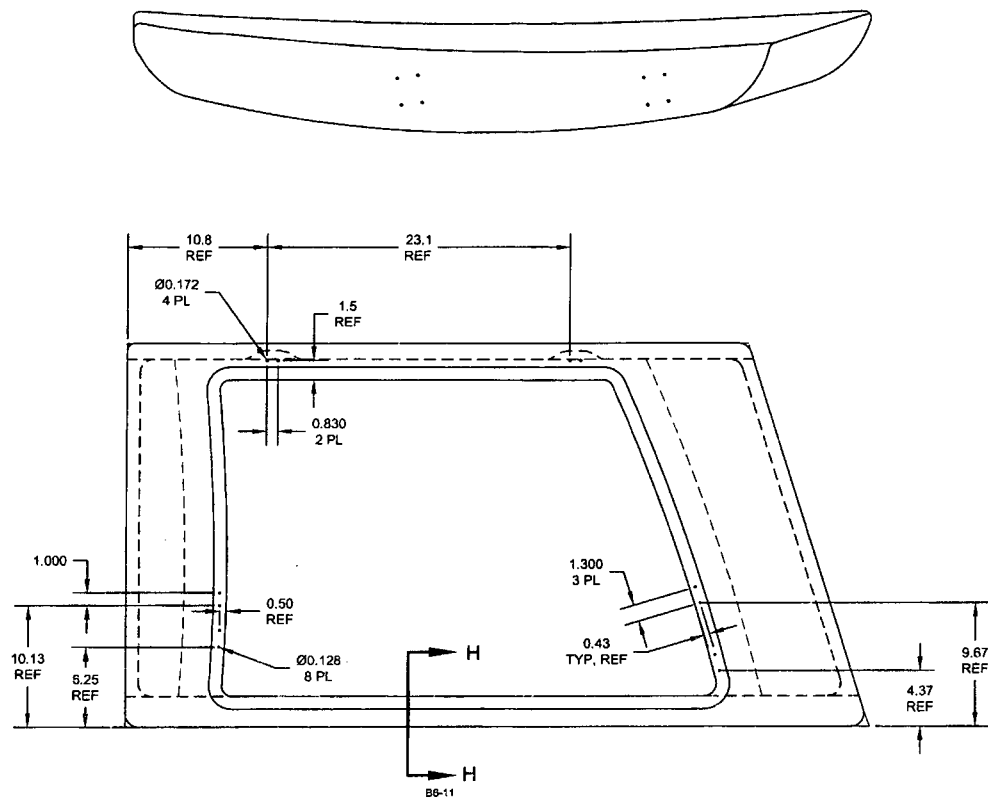
D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2009-10-20
NAD

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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105740



D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

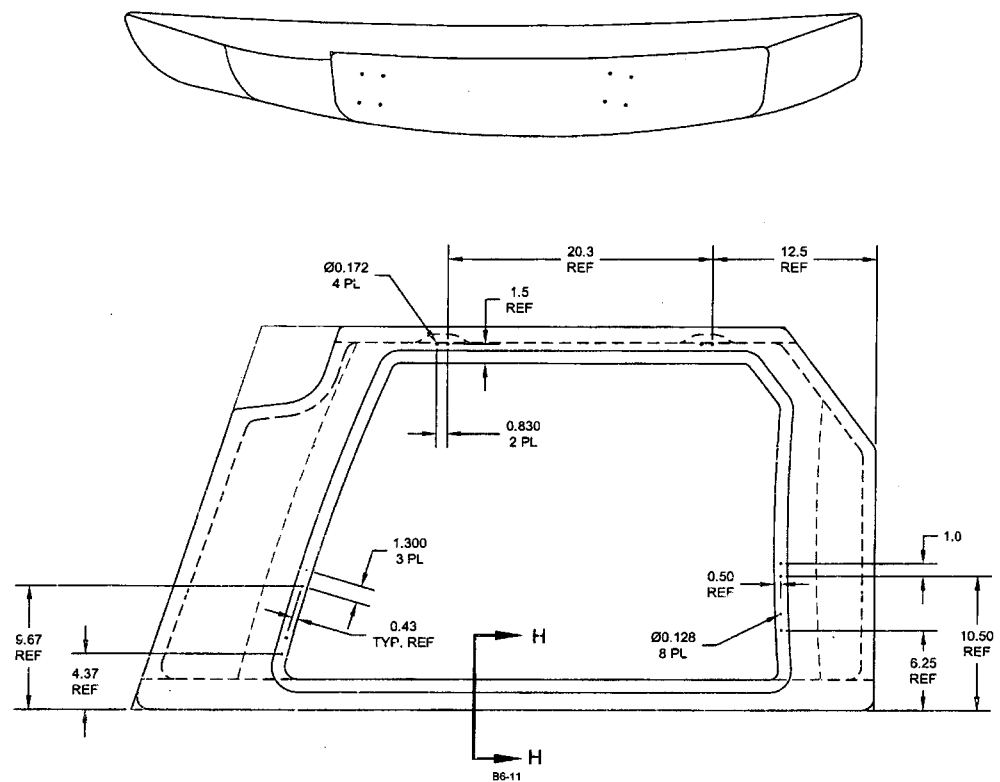
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2009-10-20
NP

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	#	DRAWING NO.	REV. F
MFG. APPR.	#	D3188	SHEET 3 OF 11
APPROVED	#	TITLE	SCALE
DE APPR.	#	SPACEPOD BODY	NTS
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105740



D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

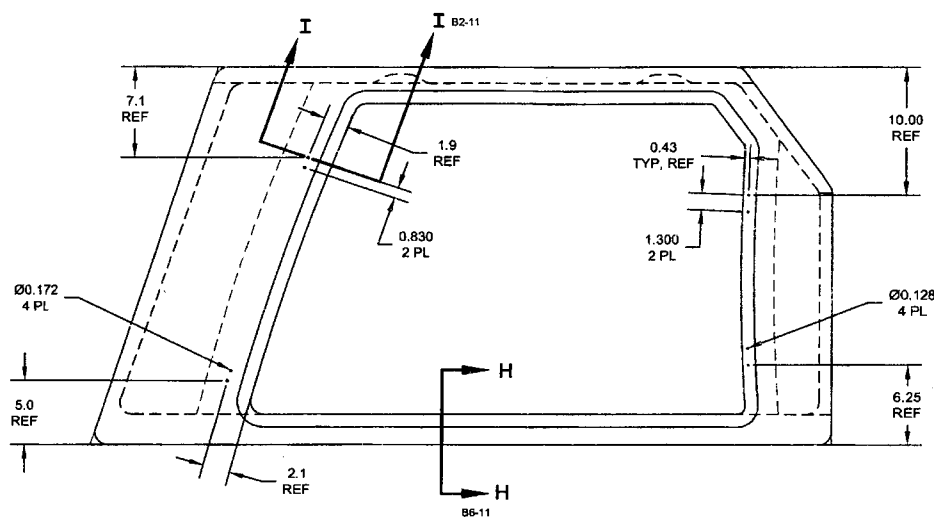
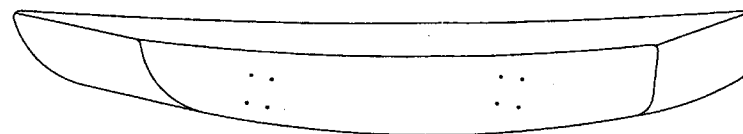
RELEASED
2009-10-20
NO

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 4 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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105740



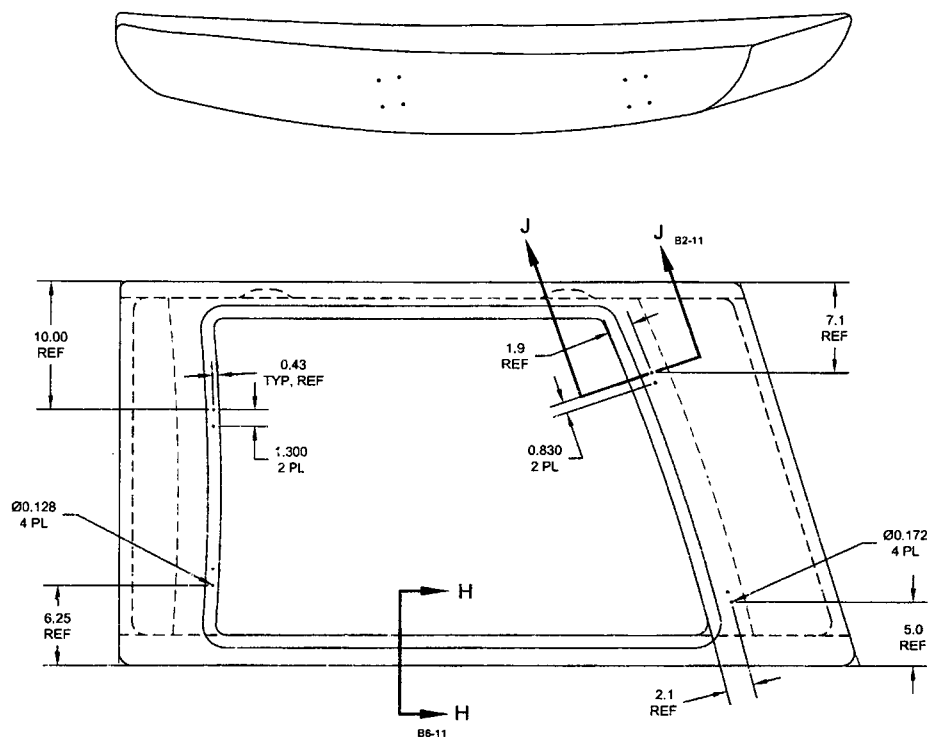
D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

RELEASED
2009-10-20
MD

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 5 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

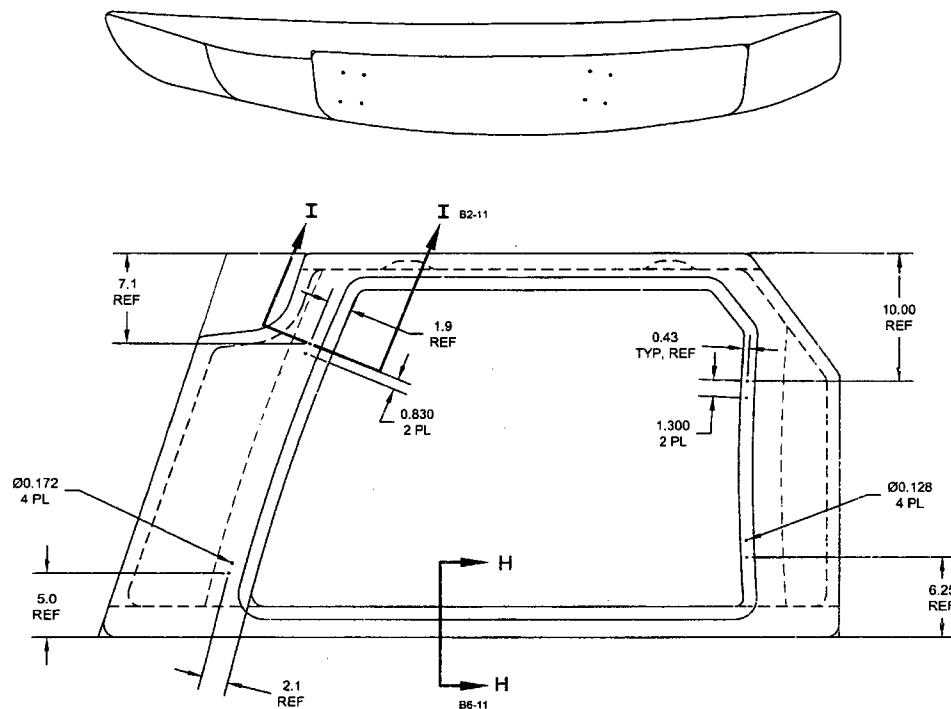
RELEASED
2009-10-20
M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 6 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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105740



D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

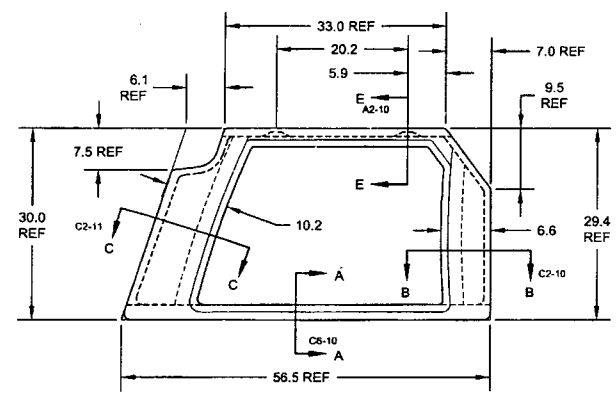
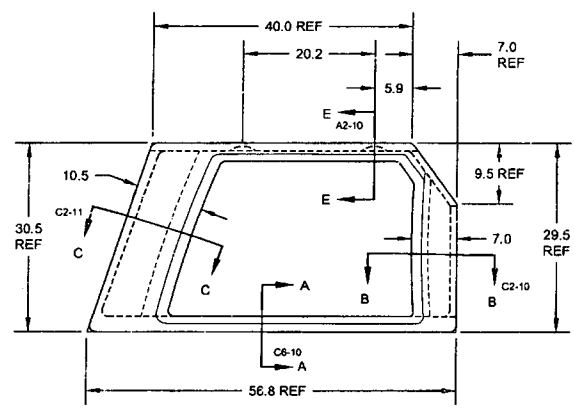
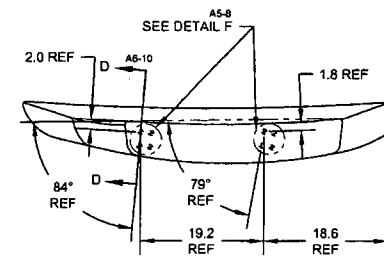
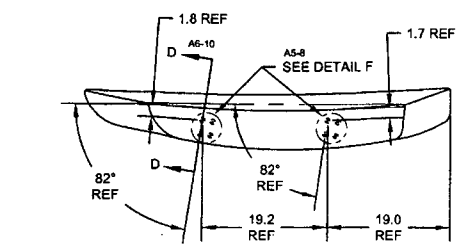
NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

RELEASED
2009-10-20
M

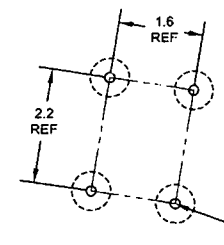
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 7 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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D3188-1M SPACEPOD BODY

D3188-3M SPACEPOD BODY



DETAIL F

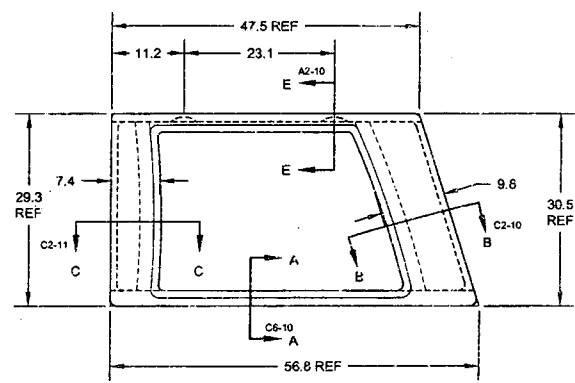
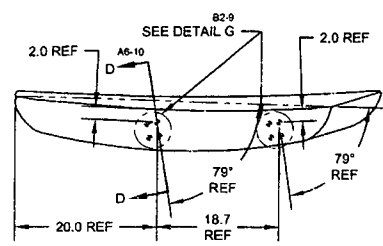
INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

- D3188-1M/-3M NOTES:**
 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
 2) SEE SHEET #10 FOR SECTION VIEWS.

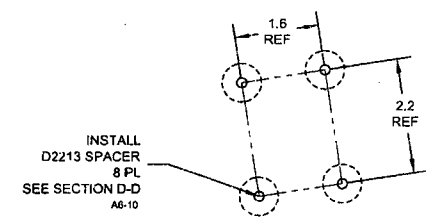
RELEASED
 2009-10-23

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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D3188-2M SPACEPOD BODY



DETAIL G D6-9

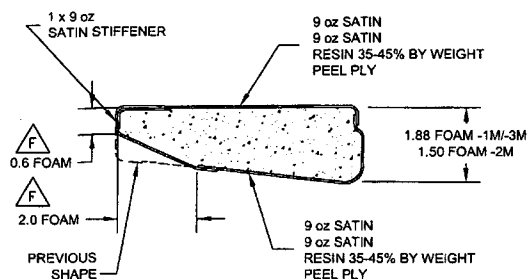
RELEASED
2009-10-20

D3186-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 9 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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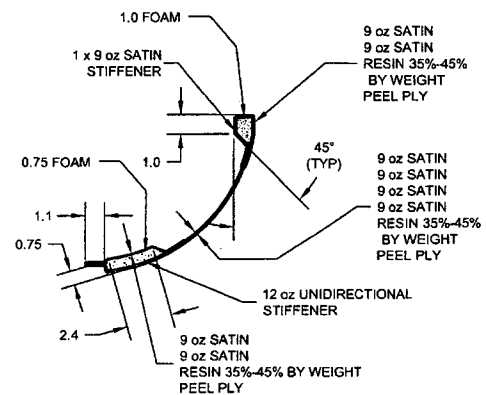
105740

OUTBOARD



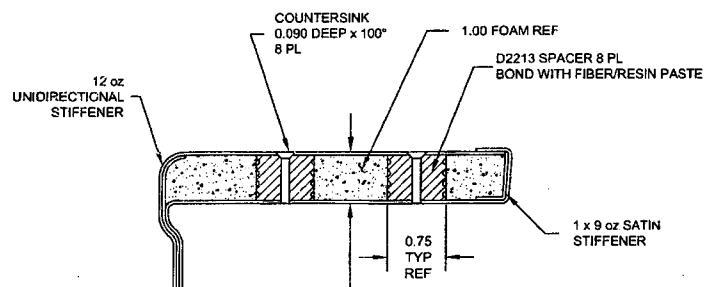
SECTION A-A
TYPICAL FLOOR SECTION

B7-8
B3-8
B6-9



SECTION B-B
SECTION C-C OPPOSITE

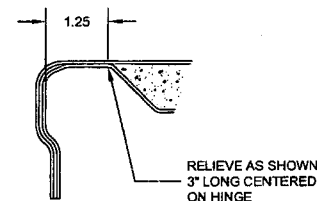
B6-8
B8-8
B4-8
B2-8
B7-9
B5-9



SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS

D3-8
D7-8
D6-9

9 oz SATIN
9 oz SATIN
18 oz CLOTH
1.00 FOAM
9 oz SATIN
9 oz SATIN
RESIN 35-45% BY WEIGHT
PEEL PLY



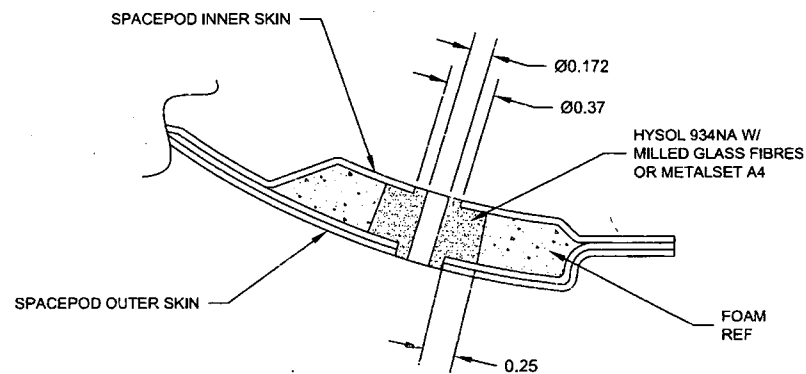
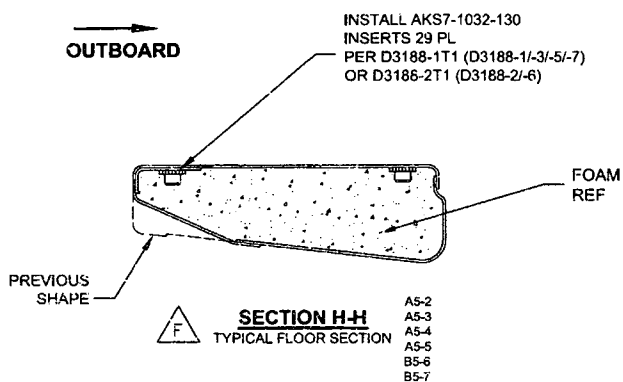
SECTION E-E
2 PLACES PER POD

C2-8
C7-8
B6-9

RELEASED
2009-10-27

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO.	REV. F
MFG. APPR.	JB	D3188	SHEET 10 OF 11
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	SPACEPOD BODY	NTS
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105740



SECTION I-I
SECTION J-J OPPOSITE
4 PLACES PER POD

RELEASED
2009-10-20

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	W	DRAWING NO.	REV. F
MFG. APPR.	W	D3188	SHEET 11 OF 11
APPROVED	W	TITLE	SCALE
DE APPR.	W	SPACEPOD BODY	NTS
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DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-600 REV E AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-600 REV 5**

REF. TCCA STC: SH93-88
REF. FAA STC: SR00098NY and SR00099NY
REF. EASA STC EASA.IM.R.S.01292

1.0 PURPOSE

In response to customer feedback, Dart is implementing changes designed to ease the mounting of hinge brackets for the forward opening Spacepod and to improve the security of the hinge assemblies. The purpose of this DSI is to introduce the DSI 9701-011 Hinge Shim Kit and to provide instructions and parts lists to install and assemble the hinges on Dart Spacepods D350-600-241/-242/-243/-247/-248/-249. One Kit is required per door.

2.0 PROCEDURE

- 2.1 Remove the D3186-3/-4 Spacepod Door by disconnecting the hinges.
- 2.2 Remove the D3538-1 Hinge Brackets and D2179 Hinge Bracket Plates. Retain all parts.
- 2.3 Re-install the D3538-1 Hinge Brackets with the D5127-3 Shims between the Spacepod and Hinge Bracket using the existing mounting holes and fasteners. See Figure 1. The D3538-1 Hinge Brackets should be oriented as per Table 1. It may be necessary to reverse the orientation, as required, on some Spacepod bodies. Furthermore, due to normal variations in the Spacepod geometry, additional shimming may be required. It is acceptable to use Hysol Liquid Shim, thin washers or shims fabricated from 6061-T6 aluminum for this purpose.
- 2.4 Torque fasteners to 9-12 in-lbs (1-1.4 N-m).

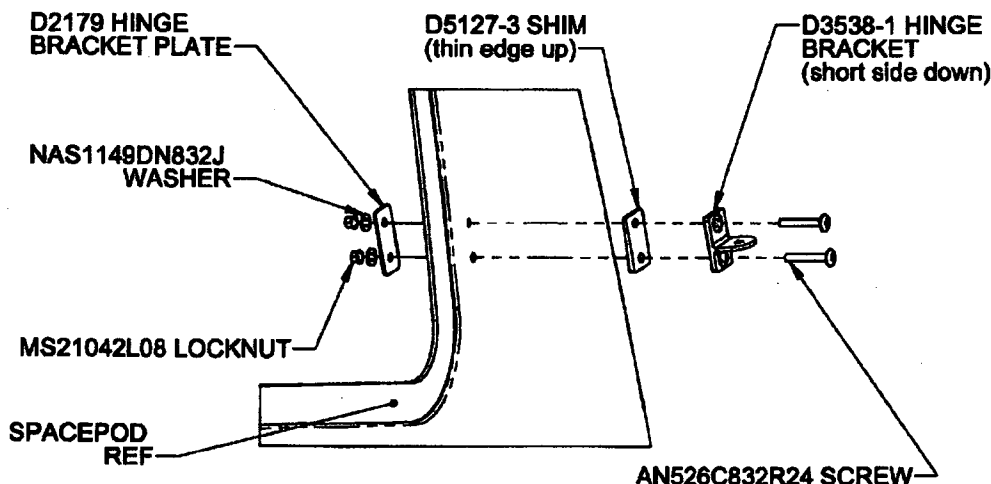


FIGURE 1: SPACEPOD HINGE INSTALLATION
(LOWER HINGE, RH DOOR SHOWN)

SPACEPOD	UPPER D3538-1 BRACKET	LOWER D3538-1 BRACKET
RIGHT SIDE	SHORT SIDE UP	SHORT SIDE DOWN
LEFT SIDE	SHORT SIDE DOWN	SHORT SIDE UP

TABLE 1: D3538-1 HINGE ORIENTATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.09.09
CERT. NO.: SH93-88
ISSUE NO.: 6

B	ADD NOTES ALLOWING USE OF ADDITIONAL SHIM MATERIALS, ALTERNATE SHIM ORIENTATION	DB	14.09.09
A	NEW ISSUE	DB	14.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	N/A	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9701	SHEET 1 OF 3
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	HINGE SHIM KIT	NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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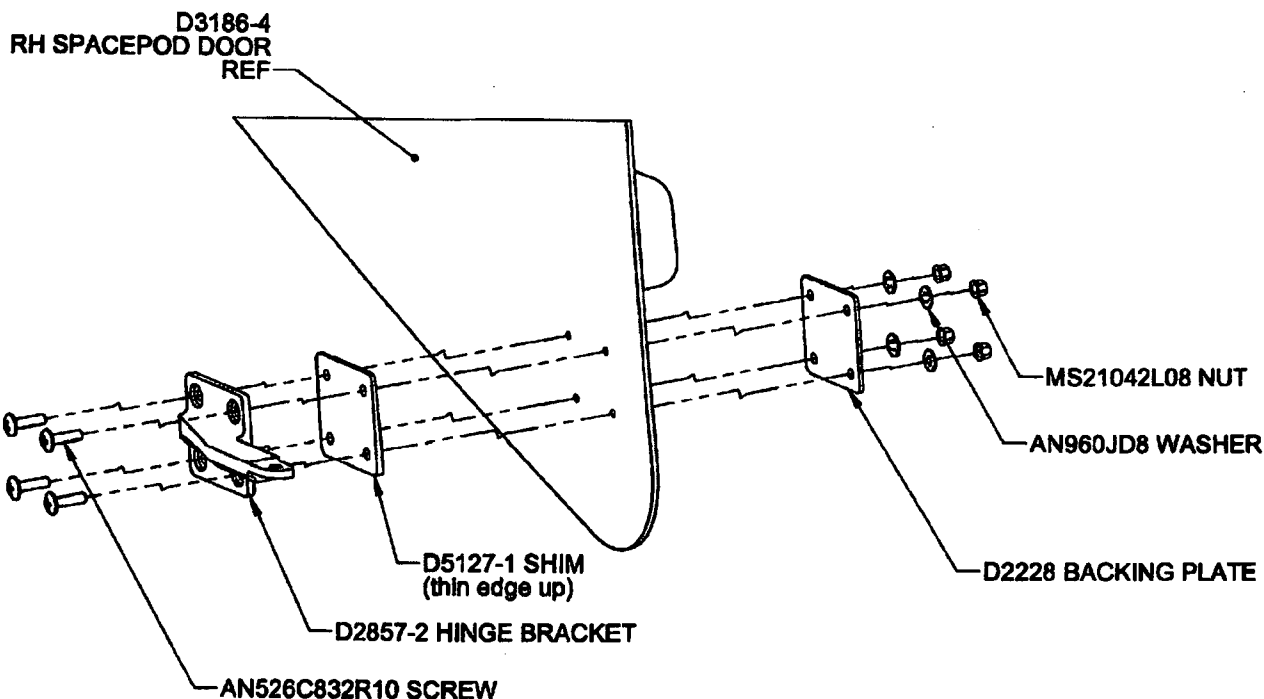


FIGURE 2: SPACEPOD DOOR HINGE INSTALLATION
(LOWER HINGE, RH DOOR SHOWN)

- 2.5 Remove the D2857-1/2 Hinge Brackets and D2228 Backing Plates. Retain all parts and fasteners.
- 2.6 Re-install the D2857-1/2 Hinge Brackets with the D5127-1 Shim between the Spacepod Door and Hinge Brackets, using the existing mounting holes and fasteners. See Figure 2. The hinge brackets should be installed as shown in Table 2. Shims can be re-oriented, as required, to provide the best mounting configuration. Furthermore, due to normal variations in the Spacepod geometry, additional shimming may be required. It is acceptable to use Hysol Liquid Shim, thin washers or shims fabricated from 6061-T6 aluminum for this purpose.
- 2.7 Torque fasteners to 9-12 in-lbs (1-1.4 N-m).
- 2.8 Re-install the D3186-3/4 Spacepod Door onto the Spacepod per Section 52.4 of ICA-D350-600. See Figure 3 for reference.

DOOR	UPPER HINGE BRACKET	LOWER HINGE BRACKET
RIGHT SIDE	D2857-1	D2857-2
LEFT SIDE	D2857-2	D2857-1

TABLE 2: HINGE SELECTION CHART

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.09.09
CERT. NO.: SH93-88
ISSUE NO.: 8

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	DB	
CHECKED	13	DRAWING NO. DSI 9701
MFG. APPR.	N/A	REV. B SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE
DE APPR.	<i>[Signature]</i>	HINGE SHIM KIT
DATE	14.09.09	SCALE NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

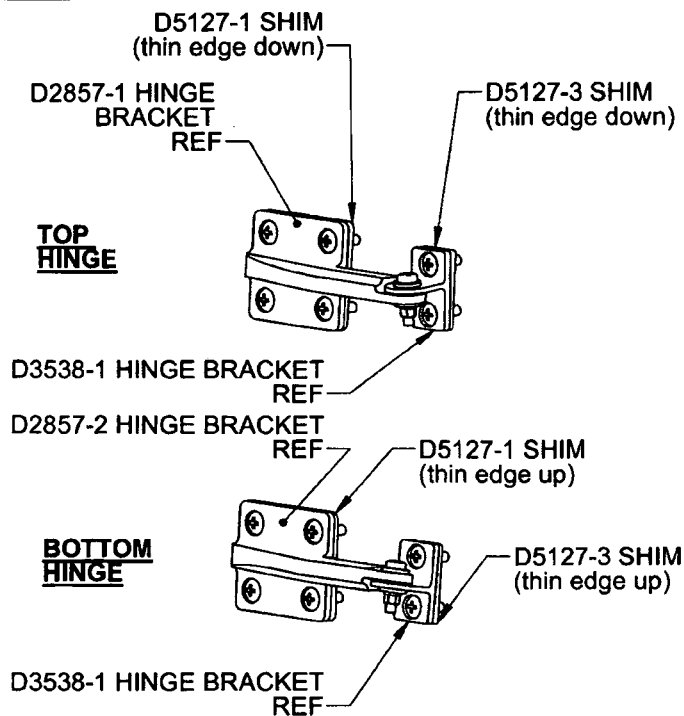


FIGURE 3: DSI 9701-011 HINGE KIT ASSY
(RH DOOR ASSY SHOWN, LH OPPOSITE)

3.0 PARTS LIST

QTY -011	P/N	DESCRIPTION
X	DSI 9701-011	HINGE SHIM KIT
2	D5127-1	SHIM, LARGE
2	D5127-3	SHIM, SMALL

4.0 WEIGHT AND BALANCE

There is no Weight and Balance change associated with this update.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO #01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.09.09
CERT. NO.: SH93-88
ISSUE NO.: 6

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9701	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HINGE SHIM KIT	NTS
DATE	14.09.09	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 105740

105740

Page 1

August-16-13 11:37:33 AM

Item ID: D350-600-242

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Spacepod Fwd Opening RH AS 350/AS 355

Stop *NS2*

Start Date: 8/16/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/13/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 130816 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3188	F								
DS19639	A								
IIN D350-600	Rev C								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-600-242 CHG001								
110	Small Fab	0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1-Drill holes in D3188-2 using drill jig DT8971 2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188 3-Deburr 4-Install inserts in D3188-2 as per Dwg D3188.								

SD
002 per ECN
14-594

MLJ 14-11-17

SDP
14/11/14

PTO